

Work Order ID 85776

Tuesday, July 03, 2012 1:50:40 PM

85776

DUPLICATE

Page 1

Item ID: D4016-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Hinge Half, Lid

Stop ***NS2***

Start Date: 6/15/2012 Start Qty: 18.00

18

Cust Item ID:

Required Date: 6/21/2012 Req'd Qty: 18.00

18

Customer:

Reference:

Approvals:

Process Plan: *muf*

Date: *12-07-03*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4016

A

100

Cut blanks as per folio

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK as per folio

aml 12/07/03

18

110

0.00

110

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA874 AND DWG

FOLIO REV: *44*

DWG REV: *4*

DEBURR

aml 12/07/04

18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

ok 12/07/04

18

9

SL 12-07-04

18

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location: *WA*

0.00

160

Packaging

Memo

0.00

Packaging

18

12/07/04 JB

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QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00


170

QC

Memo

0.00

Quality Control

12/7/5 ME
12-07-04

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Picklist Print

Tuesday, July 03, 2012 1:50:40 PM

Page 1

Work Order ID: 85776
Parent Item: D4016-3
Parent Item Name: Hinge Half, Lid

Start Date: 6/15/2012
Start Qty: 18.00
Required Date: 6/21/2012
Required Qty: 18.00

Comments: I[PP REV:A NEW ISSUE 09-11-27 JL VERIFIED BY:DD IPP Rev:B as per dwg REV.A DD
10.02.22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B1.000X1.000 304 bar 1.00 x 1.00		Purchased	No			100	f	34.0270	0.08	1.5157895			

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT050	34.027	
113290	1.047	
→ 121806	20.4	
122008	12.58	

1.52 *ml 12/07/03*

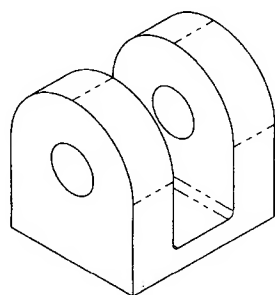
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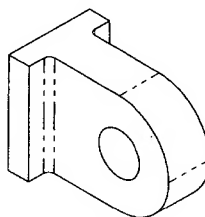
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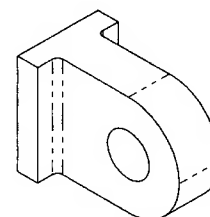
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D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID



D4016-5 HINGE HALF, LIGHT LID

#85776
RELEASED
2010-02-16
MP

A		NEW ISSUE		JPH		10.01.29			
REV.		DESCRIPTION				BY		DATE	
DESIGN		AJS		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
DRAWN		AJS							
CHECKED		MP		DRAWING NO.				REV. A	
MFG. APPR.		MP		D4016				SHEET 1 OF 2	
APPROVED		MP		TITLE				SCALE	
DE APPR.		MP		BASKET HINGE				NTS	
DATE		10.01.29		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD					

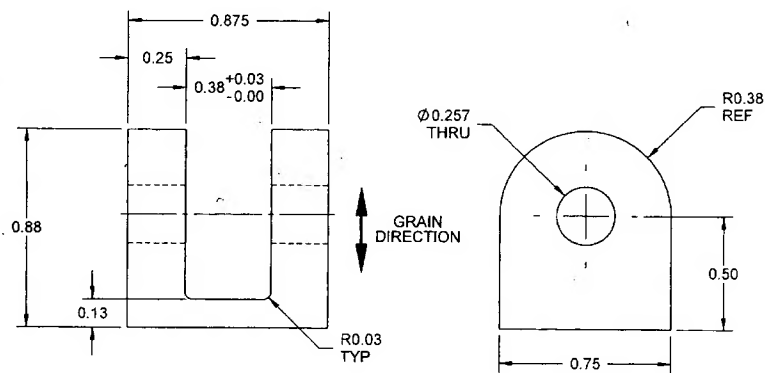
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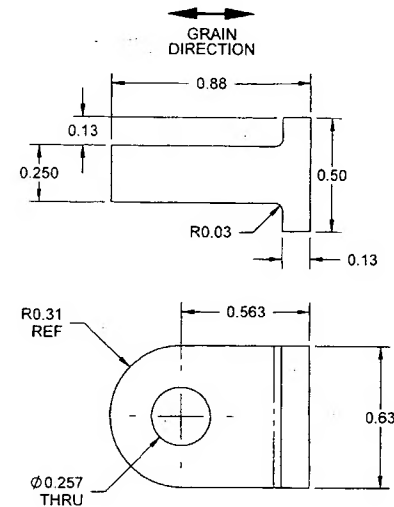
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D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID

D4016-5 HINGE HALF, LIGHT LID

NOTES:

1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR,
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT -1: 0.09 lbs

-3: 0.04 lbs

-5: 0.01 lbs

RELEASED
2010-02-16
AM

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. A
MFG. APPR.	BS	D4016	SHEET 2 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	BASKET HINGE	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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